

Work Order ID 52158 -2

Thursday, September 17, 2009 9:21:54 AM

Page 1

Item ID: D3193-041 *12* *W/O was Sp/1* Accept

Revision ID: C

Item Name: Support Bracket Assembly

Start Date: 9/17/2009 Start Qty: 12.00

Required Date: 10/2/2009 Req'd Qty: 12.00 *13*

Reference:

Approvals: Process Plan: *PL* Date: *09-9-17* Tooling: _____

QC: _____ Date: _____ SPC (Y/N): _____

Cust Item ID:

Customer:

Setup Start

Stop

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr.								
D3193	Rev C								

100
BAND SAW
Bandsaw
Jeaspa Bandsaw

Memo
Cut blanks: 3.500" x 2.500" x 5.900" long Bar

0.00
0.00

28 09/10/08

13

0

110
HAAS 1
HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

Memo
1-Machine as per Folio FA374 and Dwg D3193 Identify as D3193-1 □2-Deburr and Tumble

0.00
0.00

mf 09/10/11

12 *13*

13

*Pto
Lost
Page*

120
QC
Quality Control

QC2- Inspect parts off machine FAI/FAIB

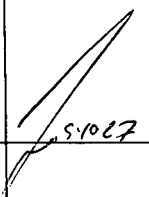
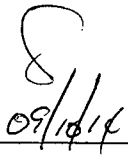
Memo

0.00
0.00

*09/10/11
mf*

12 *13*

13

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
		W/O was split for 1 per NCR	S	9/10/14	12			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Reference:

Accept

Setup Start

Stop

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC8- Inspect parts - second check

0.00

QC

Memo

0.00

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00

HandFinish

Memo

0.00

Hand Finishing

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

Powdercoat

Memo

0.00

Powder Coating

START TIME: 7:15AM OVEN TEMPERATURE:

7:45AM FINISH TIME: 3:20PM



09/10/14

09/10/14

09/10/15

12 0

12 9

12 8

Work Order ID 52158

Thursday, September 17, 2009 9:21:54 AM



Page 3

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Required Date: 10/2/2009 Req'd Qty: 12.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



QC

Quality Control

QC3- Inspect Part Finish

Memo

0.00

0.00

BR 09-10-15

(12)

170



Small Fab

Small Fab

Small Fab

Memo

Assemble D3193-041 as per Dwg D3193

0.00

0.00

EP 09/10/21 (12)

180



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

2) 09/10/22

(12)

f

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Thursday, September 17, 2009 9:21:54 AM



Page 4

Item ID: D3193-041

Accept



Setup Start



Revision ID: C

Stop



Item Name: Support Bracket Assembly

Start Date: 9/17/2009 Start Qty: 12.00



Cust Item ID:

Required Date: 10/2/2009 Req'd Qty: 12.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

Identify as per dwg & Stock Location: 480

0.00



Packaging

Memo



0.00

Packaging

9/10/23 120

200

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10.09.10.27

MF
09-10-23

Picklist Print

Page 1

Thursday, September 17, 2009 9:21:53 AM

Work Order ID: 52158

Parent Item: D3193-041RevC

Parent Item Name: Support Bracket Assembly


Start Date: 9/17/2009

Required Date: 10/2/2009

Comments:

Start Qty: 12.00

Required Qty: 12.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21073L4  NUTPLATE		Purchased	No			100	Each	76.0000	48.0000			

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

76

103693

26

112679

50

M6061T6B2.500X03.50
0

Purchased

No

170

f

29.4700

6.2021



6061-T6 Bar 2.50 x 3.50

88 02/00/09

Warehouse Loc Qty Loc Code

Location

Main Warehouse

MAT

29.47

102838

13.1

110936

1.03

111700

15.34

MS20426AD3-7

Purchased

No

170

Each

9,091.000

96.0000



RIVET

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

9091

17694

9091

103363 50

6'

17964 9/10/19 @20 SF

DART AEROSPACE LTD		Work Order:	52158
Description: Support Bracket		Part Number:	D3193-1
Inspection Dwg: D3193	Rev: C	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.435	+/-0.010	3.435	✓			
2.012	+/-0.010	2.010	✓			
1.200	+/-0.010	1.200	✓			
2.006	+/-0.010	2.005	✓			
R0.125	+/-0.010					
2.435	+/-0.005	2.436	✓			
0.281	+/-0.005	0.281	✓			
0.264	+/-0.010	0.261	✓			
5.878	+/-0.010	5.878	✓			
4.878	+/-0.005	4.879	✓			
2.550	+/-0.010	2.548	✓			
15°	+/-0.5°					
0.260	+/-0.010	0.260	✓			
R0.05	+/-0.030					
Ø0.266	+0.006/-0.001	Ø 0.268	✓			
Ø0.098	+0.004/-0.001	Ø 0.101	✓			
Ø0.180 x 100°	+0.005/-0.001	0.177	✓			
0.850	+/-0.010	0.855				
R0.125	+/-0.010					
0.255	+/-0.010	0.255	✓			
2.812	+/-0.010	2.811	✓			

Measured by:	<i>[Signature]</i>	Audited by:	<i>[Signature]</i>	Prototype Approval:	N/A
Date:	09/10/10	Date:	09/10/14	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.02.28	New Issue P/O D3193-041	KJ/DD	
B	09.05.04	R0.50 was R0.050	KJ/DD <i>[Signature]</i>	<i>[Signature]</i>

